

Work Order ID 54638 - 1

December 15, 2009 9:59:13 AM



Page 1

Item ID: D3774-3

Accept



Setup Start



Revision ID:

Item Name: Seat Back, LH/RH

Stop



Start Date: 15/12/2009 Start Qty: 20.00

Required Date: 18/12/2009 Req'd Qty: 20.00



Cust Item ID:

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3774

Rev B

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Set up machine program D3774-3 Set up clamping frame as per folio

OK 10/01/08

110

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

OK 10/01/08

X 11

120

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D32811 and Folio FTA 011 Dwg. Rev.

B Folio Rev. A

OK 10/01/08

X 11

**Work Order ID 54638**

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Page 2

Item ID: D3774-3

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Stop



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Start Date: 15/12/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 18/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

DL 10/01/08  
X 11

140

HAND FINISHING THERMOFORMING

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions

BB 10/01/12  
X 11

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1) Check dimensions to ensure conformity to drawing tolerances.

BB 10/01/12  
X 11

**Work Order ID 54638**

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Page 3

Item ID: D3774-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Back, LH/RH

Start Date: 15/12/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 18/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

⇒ 5/10/12



Quality Control

170

Identify as per dwg & Stock Location 257

0.00



Packaging

Memo

0.00

16-1-12 1102

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/13  
MF 10-01-12

# Picklist Print

December 15, 2009 9:59:18 AM

Page 1

Work Order ID: 54638



Parent Item: D3774-3



Parent Item Name: Seat Back, LH/RH

Start Date: 15/12/2009

Required Date: 18/12/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining # Qty To Pick	Qty Issued	Date Issued	Status
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MLEXS.125-F60029-04 Purchased No

100 sf 2,011.175 213.3400



GE PLASTICS LEXAN SHEET

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

2011.175198

103106

1.6765

105330

47.8767

109455

40.5717

111710

329.893632

112585

1591.15667

x 4 = 10.667

117.337 sq ft.

Dk 10/01/08.



DART AEROSPACE LTD		Work Order:	54638
Description: Seat Back		Part Number:	D3774-3
Inspection Dwg: D3774	Rev: B	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 10/01/12

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3	+/-0.100	1.361	✓			
33.9	+/-0.100	33.9	✓			
0.085	Min	.094	✓			
0.100	Min	.110	✓			
0.100	Min	.114	✓			
0.100	Min	.113	✓			
0.100	Min	.116	✓			
0.100	Min	.117	✓			
0.100	Min	.114	✓			
0.100	Min	.106	✓			
0.100 .065	Min	.080	✓			

Measured by: BB

Date: 10/01/12

Audited by: BH

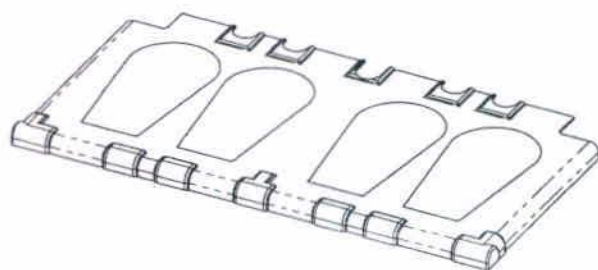
Date: 10/01/12

Prototype Approval:

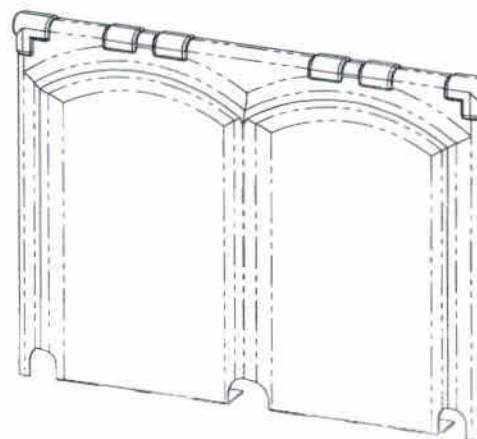
N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DL	
B	09.05.19	Dimension 17.4 removed	KJ	



D3774-1 SEAT BOTTOM

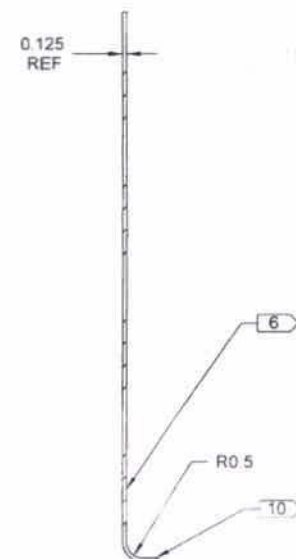
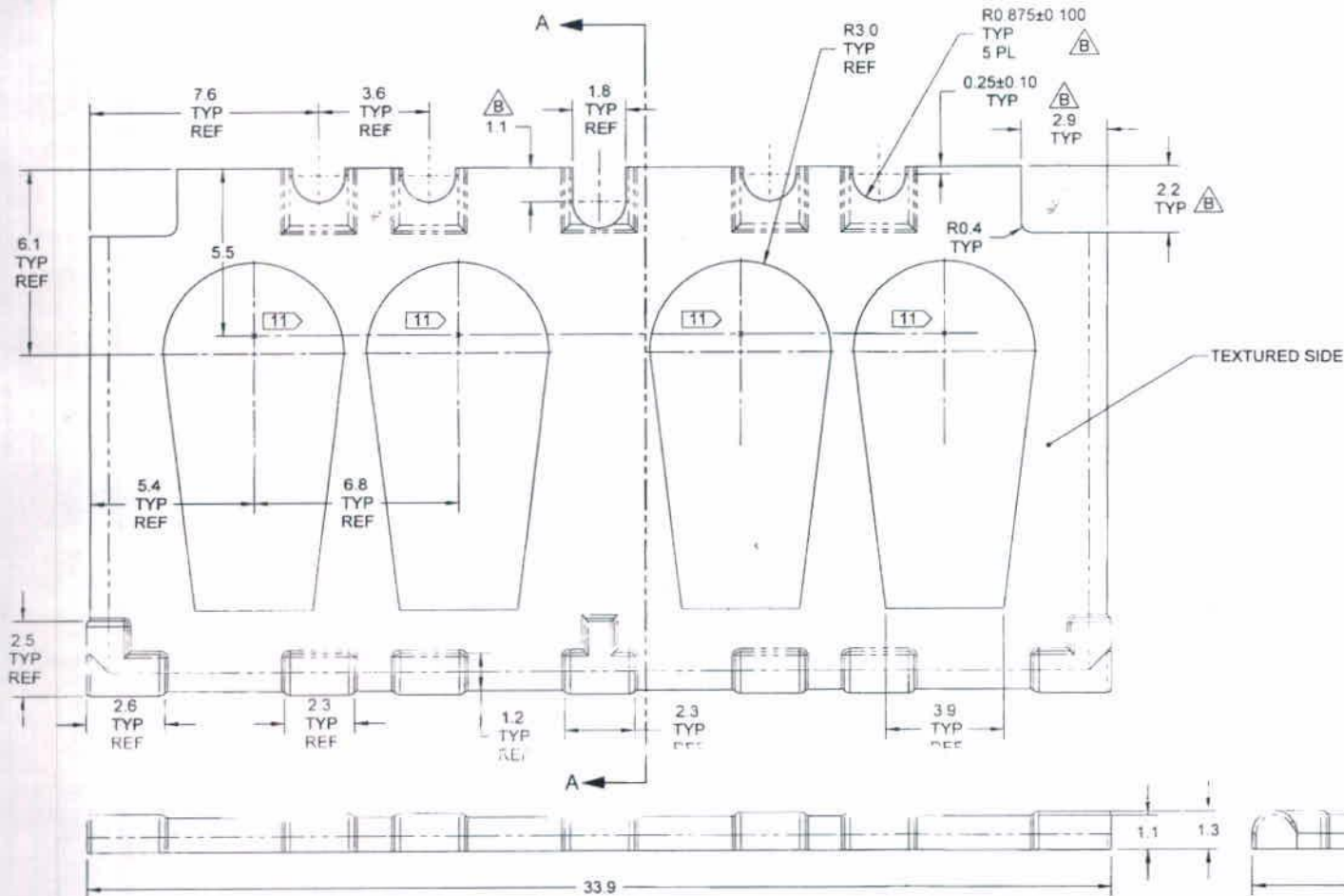


D3774-3 SEAT BACK

**RELEASED**  
08-11-14

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 54638  
120912-15

B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES		PH	08.07.25
A	NEW ISSUE		HS	08.06.23
REV.	DESCRIPTION		BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	PH			
CHECKED	PH	DRAWING NO.	REV. B	
MFG. APPR.	PH	D3774	SHEET 1 OF 3	
APPROVED	PH	TITLE	SCALE	
DE APPR.	PH	SEAT	NTS	
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SECTION A-A

**D3774-1 SEAT BOTTOM**

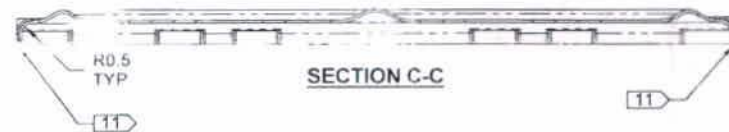
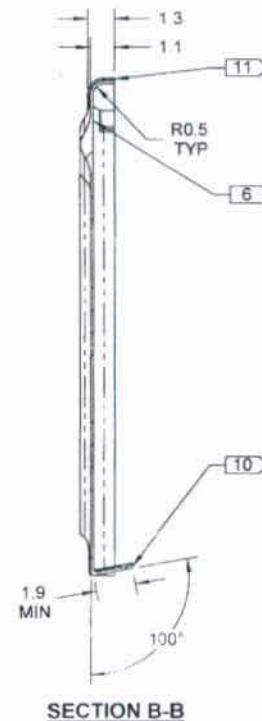
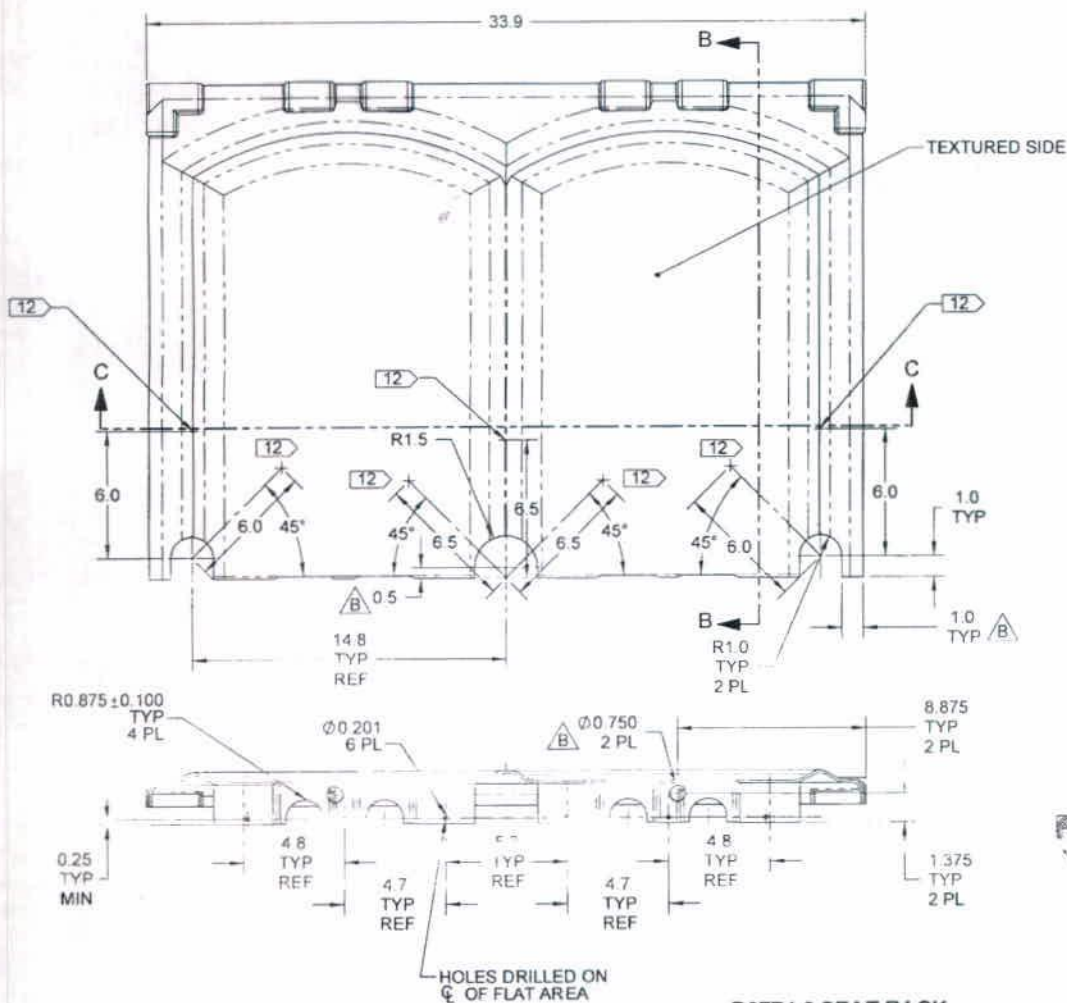
**RELEASED**  
08-06-11

*wlo 5463f*

NOTES:  
MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS 125-F60029-04)  
FINISH: NONE  
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
UNITS: INCHES UNLESS OTHERWISE NOTED  
BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-1" USING VIBRATING STYLUS  
WEIGHT: 2.93 lbs  
PART TO BE PRODUCED FROM MOLD DT9022 AND PER DART QSI 022  
OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9022  
MINIMUM MATERIAL THICKNESS AFTER FORMING ON FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085  
MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>HS</i>		
CHECKED	<i>HS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>HS</i>	D3774	SHEET 2 OF 3
APPROVED	<i>HS</i>	TITLE	SCALE
DE APPR.	<i>HS</i>	SEAT	NTS
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**D3774-3 SEAT BACK**

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 FINISH: NONE  
 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 UNITS: INCHES UNLESS OTHERWISE NOTED  
 BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-3" USING VIBRATING STYLUS  
 WEIGHT: 4.82 lbs  
 PART TO BE PRODUCED FROM MOLD DT9023 AND PER DART QSI 022  
 OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9023  
 ) MINIMUM MATERIAL THICKNESS AFTER FORMING ON BOTTOM FLANGE IS 0.085  
 ) MINIMUM MATERIAL THICKNESS AFTER FORMING FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085  
 ) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

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 08-07-25

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